



NOTES:

1. THIS IS A ULTRA - HIGH - VACUUM ASSEMBLY (UHV) KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND AND WRAP UP FOR PACKING WITH ALUMINUM FOIL
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. THE ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10 -10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

REF. SOURCE

2 STANDARD BELLOWS CO.
375 ELLA T. GRASSO TURNPIKE
WINDSOR LOCKS, CT. 06096
1-203-623-2307
FAX: 203-623-0398

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651
1-800-443-8817
FAX: 1-510-887-0626

3	#572-403-8-EE	WELDED BELLOWS	SST	1
2	#120026	6" O.D. TAPPED ROTATABLE VACUUM FLANGE	SST	1
1	#130026	6" O.D. TAPPED NONROTATABLE VACUUM FLANGE	SST	1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .X - .03 [.7620] .XX - .01 [.25] .XXX - .005 [.127] ANGULAR - .25 SURFACE ROUGHNESS 125 REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5 DO NOT SCALE DRAWING		LOG NUMBER V2640000-00		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DRAWN BY Fuhrmann	DATE 3/14/97	CHIEF DESIGN ENGINEER D.Shu	DATE	TITLE ADVANCED PHOTON SOURCE V2-64 WELDED BELLOWS ASS'Y 6" CF-4" I.D. X 269 mm	
CHECKED BY D.Shu		GP LEADER T.M.Kuzay			
DESIGNER Shu/Fuhrmann		PROJECT MGR.			
RESPONSIBLE ENGINEER D.Shu		APPROVED/RELEASED			
MATERIAL SEE PARTS LIST		SCALE 1:1		DRAWING NUMBER V2-640000-00	
		SHEET 1 of 1		C	

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			